



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6705G00132-3G

Job Sheet 186960



007914

Part No: RBW6705G00132-3G

Job Qty: 1 pcs

Part Name: AW139 Main Rotor & Tail Rotor Rigging Pin



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/23/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6705G00132-3G Rev A1 IPP Rev A 17.11.20 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1 <i>MLC</i>	1 pcs	12/14/18		0.00	1.00	Small Fab - 1		<i>MLC</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	12/14/18		0.00	0.00	QC 5 - 10		<i>DAS</i> 58 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
120	Packaging 3-1 - Stock - B4B	1 pcs	12/14/18		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



Container No: S152339



Part: RBW6705G00132 - 3G

Job No: 186960

Serial No/Batch: S152339

Revision: 1A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/11/19

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	HLL
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAS
				Packaging 3 - 36 - B4B	21
					9-89
130	QC 21 - FG	1 pcs	12/14/18	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
Part Op 100 - Small Fab - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Descriptions: Pelican case APP-1550-E 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6705G00132-3G-31/-33 to RBW6705G00132-3G-27 foam as per DWG. 6-Glue foam to case and pack case as per DWG. 110 - QC5- Inspect part completeness to step on W/O 120 - Identify as per dwg & Stock Location: _____ 130 - QC21- Final Inspection - Work Order Release)					

GA

FEB 12 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1550-E <i>138A ou 151F</i>	Case	1 Ea (1 ea)	100-Small Fab - 1	<i>5070783</i>
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	100-Small Fab - 1	<i>5021040</i>
RBW6705G00132-3G-27 <i>138A ou 151F</i>	Bottom Foam (Y20, Black), (5-3/4 x 14-1/4 x 18-7/8) use in case APP-1550-E	1 Ea (1 ea)	100-Small Fab - 1	<i>5070785</i>
RBW6705G00132-3G-29 <i>138A ou 151F</i>	Lid Foam (Y20, Black), (1-3/4 x 14-1/4 x 18-5/8) use in case APP-1550-E	1 Ea (1 ea)	100-Small Fab - 1	<i>5070786</i>
<i>93</i> RBW6705G00132-3G-31	Identification Placard	1 pcs (1 ea)	100-Small Fab - 1	<i>5061213</i>
<i>93</i> RBW6705G00132-3G-33	Location Placard	1 pcs (1 ea)	100-Small Fab - 1	<i>5061223</i>
<i>99</i> RBW6705G02031-3G	Rigging Pin Assembly N1	1 pcs (1 ea)	100-Small Fab - 1	<i>5045787</i>
<i>99</i> RBW6705G02131-3G	Rigging Pin Assembly N2	3 pcs (3 ea)	100-Small Fab - 1	<i>5058584</i>
<i>99</i> RBW6705G02231-3G	Rigging Pin Assembly N3	2 pcs (2 ea)	100-Small Fab - 1	<i>5058747</i>
<i>99</i> RBW6705G02331-3G	Rigging Pin Assembly N4	1 pcs (1 ea)	100-Small Fab - 1	<i>5058643</i>
<i>99</i> RBW6705G02431-3G	Main Rotor Actuator Lever Rigging Fork	3 pcs (3 ea)	100-Small Fab - 1	<i>5044514</i>
<i>138</i> RBW6705G02532-3G	Main Rotor Actuator Stroke Gag	3 pcs (3 ea)	100-Small Fab - 1	<i>5148250</i>
<i>99</i> RBW6705G02631-3G	Tail Rotor Actuator Lever Rigging Fork	1 pcs (1 ea)	100-Small Fab - 1	<i>5044467</i>
<i>138</i> RBW6705G02732-3G	Tail Rotor Actuator Stroke Gag	1 pcs (1 ea)	100-Small Fab - 1	<i>5130178</i>
<i>99</i> RBW6705G02831-3G	Warning Flag	1 pcs (1 ea)	100-Small Fab - 1	<i>5060198</i>
<i>-</i> RBW6705G02931-3G	Tail Rotor Actuator Black Simulator Tool	1 pcs (1 ea)	100-Small Fab - 1	<i>5153046</i>
<i>98</i> RBW6705G0	ulator Tool	1 pcs (1 ea)	100-Small Fab - 1	<i>5148242</i>
<i>99</i> RBW6705G0		2 pcs (2 ea)	100-Small Fab - 1	<i>5044229</i>

CRBT 18559
187956

Job Allocations

Operation	Required	Inventory	Allocated
100-Small Fat	1	14	0
	1	484	0
RBW6705G00132-3G-27	1	3	0
RBW6705G00132-3G-29	1	3	0
RBW6705G00132-3G-31	1	4	0
RBW6705G00132-3G-33	1	4	0
RBW6705G02031-3G	1	6	0
RBW6705G02131-3G	3	3	0
RBW6705G02231-3G	2	5	0
RBW6705G02331-3G	1	5	0
RBW6705G02431-3G	3	4	0
RBW6705G02532-3G	3	0	0
RBW6705G02631-3G	1	6	0
RBW6705G02732-3G	1	5	0
RBW6705G02831-3G	1	6	0
RBW6705G02931-3G	1	0	0
RBW6705G03031-3G	1	0	0
RBW6705G04131-3G	2	2	0

Part Specifications

Specifications could not be found.



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Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/14/18	0.00	0.00	Start Up Small Fab-3		
100	Small Fab	1 pcs		12/14/18	0.00	1.00	Small Fab-9		
110	QC	1 pcs		12/14/18	0.00	0.00	QC5		
120	Packaging	1 pcs		12/14/18	0.00	0.00	Packaging3		
130	QC21-FG	1 Ea		12/14/18	0.00	0.00	QC21		

Part Op 100 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1550-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBW6705G00132-3G-31/-33 to RBW6705G00132-3G-27 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1550-E	Case	1 Ea (1 ea)	90-Start up Operation	
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	
RBW6705G00132-3G-27	Bottom Foam (Y20, Black), (5-3/4 x 14-1/4 x 18-7/8) use in case APP-1550-E	1 Ea (1 ea)	90-Start up Operation	
RBW6705G00132-3G-29	Lid Foam (Y20, Black), (1-3/4 x 14-1/4 x 18-5/8) use in case APP-1550-E	1 Ea (1 ea)	90-Start up Operation	
RBW6705G00132-3G-31	Identification Placard	1 Ea (1 ea)	90-Start up Operation	
RBW6705G00132-3G-33	Location Placard	1 Ea (1 ea)	90-Start up Operation	
RBW6705G02031-3G	Rigging Pin Assembly N1	1 Ea (1 ea)	90-Start up Operation	
RBW6705G02131-3G	Rigging Pin Assembly N2	3 Ea (3 ea)	90-Start up Operation	
RBW6705G02231-3G	Rigging Pin Assembly N3	2 Ea (2 ea)	90-Start up Operation	
RBW6705G02331-3G	Rigging Pin Assembly N4	1 Ea (1 ea)	90-Start up Operation	
RBW6705G02431-3G	Main Rotor Actuator Lever Rigging Fork	3 Ea (3 ea)	90-Start up Operation	
RBW6705G02532-3G	Main Rotor Actuator Stroke Gag	3 Ea (3 ea)	90-Start up Operation	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

RBW6705G02631-3G	Tail Rotor Actuator Lever Rigging Fork	1 Ea (1 ea) 90-Start up Operation
RBW6705G02732-3G	Tail Rotor Actuator Stroke Gag	1 Ea (1 ea) 90-Start up Operation
RBW6705G02831-3G	Warning Flag	1 Ea (1 ea) 90-Start up Operation
RBW6705G02931-3G	Tail Rotor Actuator Black Simulator Tool	1 Ea (1 ea) 90-Start up Operation
RBW6705G03031-3G	Main Rotor Actuator Black Simulator Tool	1 Ea (1 ea) 90-Start up Operation
RBW6705G04131-3G	Rigging Pin Assembly No.5	2 Ea (2 ea) 90-Start up Operation

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	APP-1550-E	1	13	0
	RB41011	1	694	0
	RBW6705G00132-3G-27	1	2	0
	RBW6705G00132-3G-29	1	2	0
	RBW6705G00132-3G-31	1	4	0
	RBW6705G00132-3G-33	1	4	0
	RBW6705G02031-3G	1	6	0
	RBW6705G02131-3G	3	3	0
	RBW6705G02231-3G	2	5	0
	RBW6705G02331-3G	1	5	0
	RBW6705G02431-3G	3	4	0
	RBW6705G02532-3G	3	7	0
	RBW6705G02631-3G	1	6	0
	RBW6705G02732-3G	1	5	0
	RBW6705G02831-3G	1	6	0
	RBW6705G02931-3G	1	0	0
	RBW6705G03031-3G	1	0	0
	RBW6705G04131-3G	2	2	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



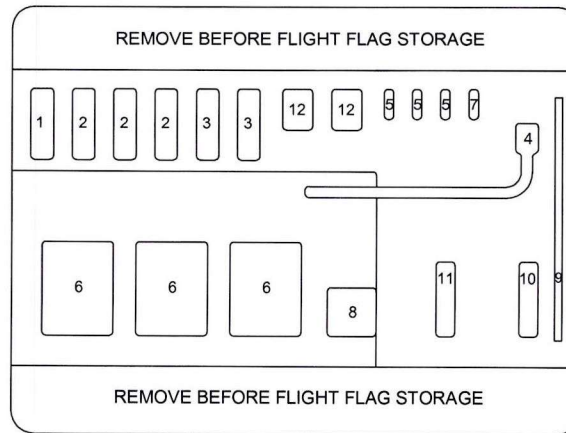
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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REVISIONS				
REV	ECN	DESCRIPTION	DATE	INITIAL APPROVED
A		CH'D -29 CUTOUT TO TWO SEPARATE RECESSED POCKETS FOR -31 & -33 PLACARD PER RW.	4/25/11	RJC
1		-ASSEMBLY CORRECTED BOM, -31 & -33 REMOVED CUTOUT FOR ADHESIVE BACK BOM MATERIAL WAS ALUMINUM IS PLASTIC. -29 ADDED CUTOUT FOR CLEARANCE TO BOTTOM OF FOAM. -31 CH'D LETTERS COLOR FROM ALUMINUM LINES AND LETTERS TO WHITE LINES AND LETTERS. -33 CH'D LETTERS COLOR FROM ALUMINUM LINES AND LETTERS TO WHITE LINES AND LETTERS.	2/14/13	BIM RJC
1A	14-0134	CH'D TITLE BLOCK WAS RED BARN IS DART. CH'D T/N WAS RBW6705G00131-3G IS RBW6705G00132-3G. -11 CH'D B/O INFO WAS RBW6705G02531-3G IS RBW6705G02532-3G. -16 CH'D B/O INFO WAS RBW6705G02731-3G IS RBW6705G02732-3G. CH'D PLACARD WAS RED BARN RB41009 IS DART RB41011. -27 CH'D DIMS WAS 1.62 IS 1.80, 1.63 IS 1.40, DELETED DIM 4X 1.00, ADDED DIM 4X 1.00 X 45°. -31 DELETED NON-CRITICAL DIMS. CH'D DIM WAS .063 IS (.063). CH'D P/N'S ON PLACARD WAS RBW6705G02531-3G IS RBW6705G02532-3G. WAS RBW6705G02731-3G IS RBW6705G02732-3G. -33 DELETED NON-CRITICAL DIMS. CH'D DIM WAS .063 IS (.063). -31 & -33 WAS B/O IS NOW DONE IN HOUSE.	8/18/14	DPD RJC

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186960 HCS
1871-23

ASSY QTY	BO	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	RIGGING PIN ASSEMBLY N'1		RBW6705G02031-3G	1
		-3	3	RIGGING PIN ASSEMBLY N'2		RBW6705G02131-3G	1
		-5	2	RIGGING PIN ASSEMBLY N'3		RBW6705G02231-3G	1
		-7	1	RIGGING PIN ASSEMBLY N'4		RBW6705G02331-3G	1
		-9	3	M/R ACTUATOR LEVER RIGGING FORK		RBW6705G02431-3G	1
		-11	3	M/R ACTUATOR STROKE GAG		RBW6705G02532-3G	1
		-13	1	T/R ACTUATOR LEVER RIGGING FORK		RBW6705G02631-3G	1
		-15	1	T/R ACTUATOR STROKE GAG		RBW6705G02732-3G	1
		-17	1	WARNING FLAG		RBW6705G02831-3G	1
		-19	1	M/R ACTUATOR BLOCK SIMULATION TOOL		RBW6705G03031-3G	1
		-21	1	T/R ACTUATOR BLOCK SIMULATION TOOL		RBW6705G02931-3G	1
		-23	2	RIGGING PIN ASSEMBLY N'5		RBW6705G04131-3G	1
	BO	-25	1	HARD CASE	PLASTIC	PELICAN #APP-1550-E	N/S
	BO	-27	1	BOTTOM FOAM	Y-20, BLACK	5-3/4 x 14-1/4 x 18-7/8 I. R. SPECIALTIES	2
	BO	-29	1	LID FOAM	Y-20, BLACK	1-3/4 x 14-1/4 x 18-5/8 I. R. SPECIALTIES	3
		-31	1	IDENTIFICATION PLACARD	PLASTIC	1/16 x 5 x 7	4
		-33	1	LOCATION PLACARD	PLASTIC	1/8 x 3 x 4-1/8	5
	BO	-35	1	DART PLACARD (TOP OF CASE)	ALUMINUM	RB41011	N/S

DART AEROSPACE	
TITLE M/R & T/R RIGGING PIN KIT	
DWG NO. RBW6705G00132-3G	REV 1A
MATL UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .005 FRACTIONS ± 1/8 XX ± .01 ANGLES ± 5° X ± .1	DRAWN BY PERRITT APPROVED 2/11/13 TEST FINISH SPEC UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 ± .001 IN. 015 IN. 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE 1:4	DATE 1-28-10 SHEET 1 of 5